PRIMER SURFACER, PU-MODIFIED **ESK-M6J151-A**
PRIMER SURFACER, PU-MODIFIED, MEDIUM SOLID **ESK-M6J151-A2**
PRIMER SURFACER, PU-MODIFIED, COLOURED **ESK-M6J151-A3**

1. SCOPE

The materials defined by these specifications are solvent borne stone peck resistant baking Primer/Surfacer. They are formulated for maximum surface quality and hold-out properties after baking.

2. APPLICATION

These specifications were originally released for materials used as primer/surfacer on baked EC surfaces (i.e. SK-M64J9554-C/D or WSK-M64J29-C) on bodies and small parts.

The primers are suitable for use under solvent borne topcoats (i.e. solid color SK-M98J9552-A and basecoat/clearcoat S-M32J110-B/-C/SK-M32J9553-A) as well as under waterborne basecoats (ESK-M62J26-A/SK-M32J9553-A). They are suitable for electrostatic and pneumatic spray application.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.3 COMPOSITION

3.3.1 Vehicle

Modified Polyester resins with cross-linkable functions, Aminoplast resins, blocked Isocyanates. The properties of the primer are determined by Urethane groups.

3.3.2 Pigments

Inert pigments and fillers to obtain the desired color and properties. The use of non-inert pigments and fillers, i.e. zinc oxide, zinc sulfide or calcium carbonate is not permitted.

3.3.3 Non volatile at spray viscosity
(FLTM BI 102-01, FC#3 at 25 °C)

ESK-M6J151-A (determined at 50 +/- 2 s):	min. 60%
ESK-M6J151-A2 (determined at 67 +/- 2 s):	min. 64%
Colored primers (determined at 67 +/- 2 s): ESK-M6J151-A3:	
grey:	min. 64 - 66%
(e.g. light grey, mid grey)	
inorganic pigmented chromatic colors:	min. 62 - 64%

Date	Action	Revisions
2008 05 30	Revised	NO TECHNICAL CHANGES MADE; Inserted 3.0; Deleted 3.1, 3.2, 3.9 & 4; FLTM's Updated
1991 03 01	Revised	Revised 3.3.3 C0108948200
1988 05 10	Released	SM/EQ 4490 TP K. Wolters

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	black and dark colors: (e.g. dark blue, anthracit)	min. 57 - 59%
	light colors: (e.g. light red)	min. 56 - 58%
3.3.4	Viscosity as delivered (FLTM BI 111-01)	see Initial Sample +/- 5 s
3.3.5	Density (ASTM D 1475)	see Initial Sample +/- 0.05 g/mL
3.3.6	Flashpoint, min. (ASTM D 56)	>21 °C
3.3.7	Storage Stability, min. (FLTM BI 102-03)	16 h

No settling and no increase of viscosity more than 15 s for material as supplied.

3.4 PREPARATION OF TEST PANELS

(FLTM BI 103-02, Method B,b)

3.4.1 Spray Viscosity — as specified by the supplier
(FLTM BI 111-01, FC# 3 at 25 °C)

The primer shall be reduced with Xylene (S-M14J245-A) or with Thinner (S-M14J210-A).

3.4.2 Substrate

Baked EC SK-M64J9554-C/D or WSK-M64J29-C as used in the plant.

3.4.3 Baking conditions (metal temperature)

5 minutes 165 °C; additional for investigations:
5 minutes 190 °C.

3.4.4 Top Coat

metallic: S-M32J110-B/-C or ESK-M62J26-A in combination with SK-M32J9553-A;
solid color: SK-M98J9552-A.

Note: For performance investigations, silver metallic or dark metallic as well as black or white top coat shall be used while visual appearance investigations of colored primers shall be performed with color-coordinated top coats as specified by Engineering.

Baking conditions (metal temperature):

10 minutes 130 °C and;
10 minutes 120 °C

3.4.5 Ageing — 72 h

The Test Panels have to be aged for 72 h at room temperature prior to testing.

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